

Duplicate

Dart Aerospace Ltd.

Date: Tuesday, 31/03/2009 4:08:12 PM
 User: Chantal Lavoie

Project was started on file
Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	AFT BLADE FOLD ASSY WELDMENT
Job Number :	45044		
Estimate Number :	13503		
P.O. Number :		Part Number :	PB674300109
This Issue :	31/03/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	B6743001 P.6
First Issue :	22/01/2009	Project Number :	N/A
Previous Run :	43062	Drawing Revision :	B1
		Material :	
Written By :		Due Date :	28/02/2009
Checked & Approved By :	<u>C 09/03/31</u>	Qty:	2
Comment :	Est Rev:A 08-06-25 new issue DD verified by:ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PB6743001211	Square Tubing
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Comment: Qty.: 6.0000 Each(s)/Unit Total : 12.0000 Each(s)
 Square Tubing
 batch:- 44989

mr 09.03.02 2

2.0	PB6743001209	Square Tubing
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Square Tubing
 batch:- 43013

mr 09.03.02 2

3.0	PB6743001201	Square Tubing
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)
 Square Tubing
 batch:- 44990

mr 09.03.02 2

4.0	PB6743001203	Square Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Square Tube
 batch:- 41901 x2

mr 09.03.02 2

5.0	PB6743001239	Square Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Square Tube
 batch:- 44986 x2

mr 09.03.02 2

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Part Number: PB674300109

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	PB6743001235	Outer Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Outer Tube

batch:- 345260

CMF 09.03.02 2

7.0	PB6743001229	Outer Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Outer Tube

batch:- 41489=1 45258=1

mmf 09.03.02 2

8.0	PB6743001213	Flanged Hook
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Flanged Hook

batch:- 41488

mmf 09.03.02 2

9.0	PB6743001311	Restraint
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Restraint

batch:- 41502

mmf 09.03.02 2

10.0	PB6743001277	Contoured Hinge Arm
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Contoured Hinge Arm

batch:- 24014

mmf 09.03.02 2

11.0	PB6743001243	Handle Arm Extension
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Handle Arm Extension

batch:- 43332

mmf 09.03.02 2

12.0	D34409	Tube Detent Clip Base (Supersedes B67-43)
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Tube Detent Clip Base

batch:- 41456

mmf 09.03.02 2

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Part Number: PB674300109

Job Number:



Seq. #: Machine Or Operation: Description :

13.0 D344013 Bracket (Supersedes B67-43001-273)



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bracket

batch:-

41201 x 1

41452 x 1

WF. 09.03.02 2

14.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- assemble parts on jig DT8814 and weld as per dwg PB67-43001

** ensure no burn thru after welding in tube -235 and -229 only where bushing -265 ***

09.04.01 2

15.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09-04-02 2

16.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/04/02 2

17.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

in detail D, mask in between -311 prior to paint

mask 1.750" on the end of -243 prior to paint

mask inside of D3440-9 prior to paint

18/44
M102648

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME:

11:15

OVEN TEMPERATURE:

320°

FINISH TIME:

11:45

09-04-7

18.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09/04/07 2

19.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA

09.04.01 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: B67-43001-09 PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: 1D Date: 09/04/09

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>45044</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/4/09	#14	During inspection Found that the welding position of (-311) is off by 0.100". measure 30.250" should be	<u>09.04.02</u>	ACCEPTABLE DEVIATION. HANDLE LENGTH CAN BE ADJUSTED AT FINAL ASSY. Qty <u>(1)</u>	<u>09.04.02</u>	<u>S</u> <u>09.04.02</u>	<u>09.04.02</u>	<u>S</u> <u>09.04.02</u>
		30.350". on one R.C. welder positions it in wrong location. Human error						

NOTE: Date & initial all entries

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Seq. #:

Machine Or Operation:

Description :

20.0

QC21

FINAL INSPECTION/W/O RELEASE



09/04/08 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-04-08

